

Date: Thursday, 04/12/2008 10:33:04 AM  
User: Melanie Fauteux











# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR DOUBLER
<b>Job Number</b> : 05061	
<b>Estimate Number</b> : 13149	
<b>P.O. Number</b> :	<b>Part Number</b> : D37011
<b>This Issue</b> : 04/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3701 PRELIM
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : PRELIM
<b>Previous Run</b> : 43909	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/12/2008
<b>Checked &amp; Approved By</b> : <u>MF 08-12-04</u>	<b>FOR ENGINEERING USE ONLY</b>
<b>Comment</b> : Est Rev:A 08-01-30 new issue DD verified by:ec	

**PROTOTYPE**  
**PRELIMINARY ISS**  
Rev A  
For Rev 10  
FOR ENGINEERING USE ONLY

**Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		
<b>Comment:</b> Qty.: 1.0545 sf(s)/Unit Total : 3.1635 sf(s) 6061T6 aluminium sheet .080" thick (M6061T6S080) Batch: <u>110063</u> <u>B8-12-5</u>		
2.0	WATER JET	FLOW WATER JET
		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3701 Dwg Rev: <u>PRE</u> <u>B8-12-5</u> Prog Rev: <u>Lim</u> 2- Deburr if necessary <u>B8-12-5</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
<b>Comment:</b> SECOND CHECK <u>08-12-05</u> (3)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Deburr if necessary 2- form as per dwg D3701 <u>SB 09/01/13</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 04/12/2008 10:33:04 AM  
User: , Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR DOUBLER

Job Number: 05061

Part Number: D37011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



09.06.13 (X3)

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09.01.16  
ENGINEERING  
APPROVAL

09.01.14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/14 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 138

9/1/18

PROTOTYPE  
09.01.16

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



MF 09-01-16

09/01/16  
DATE  
RELEASE  
EFFECTIVE 09-06-05  
POSITIVE RECALL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

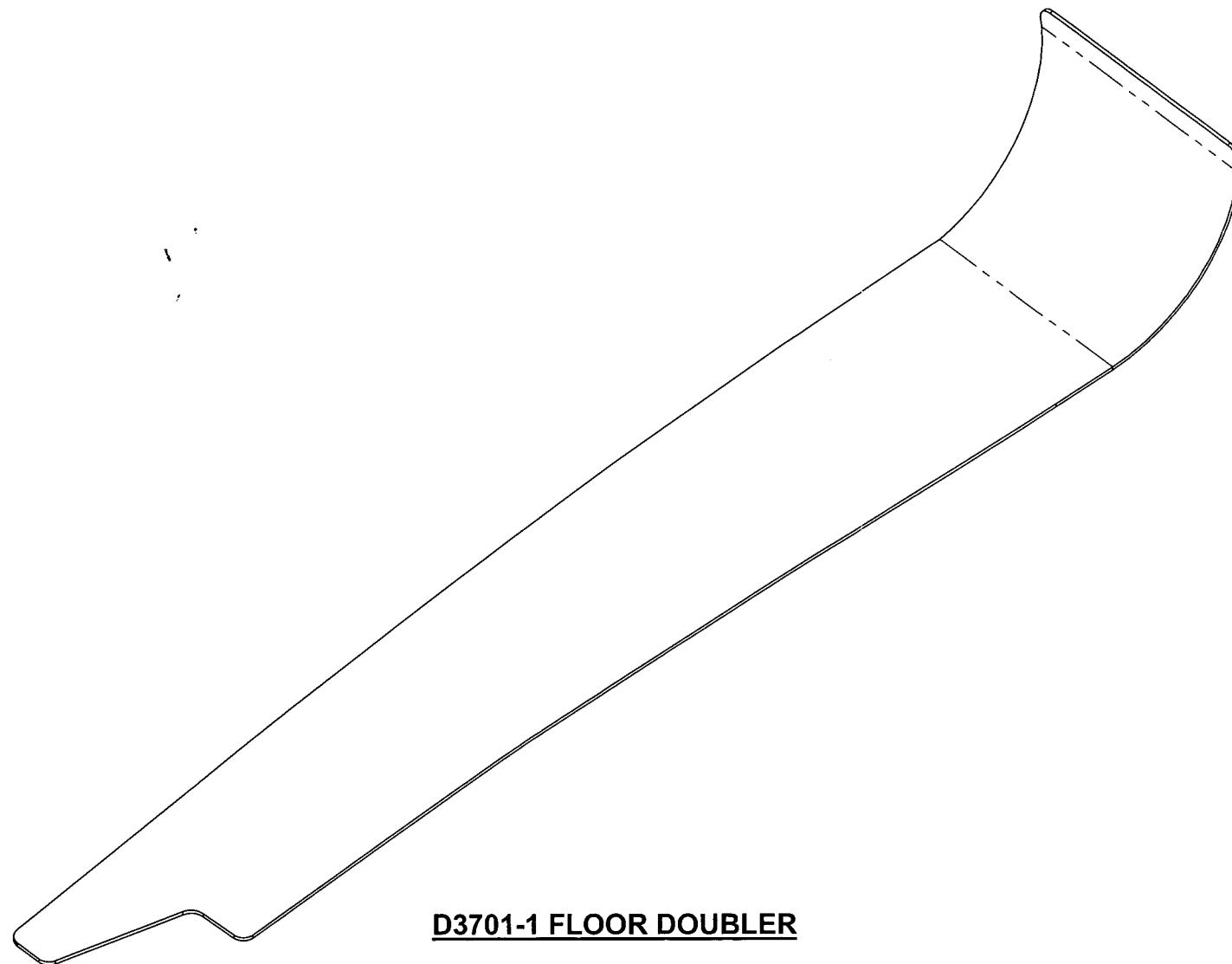
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3701-1 FLOOR DOUBLER**

**NOTES:**

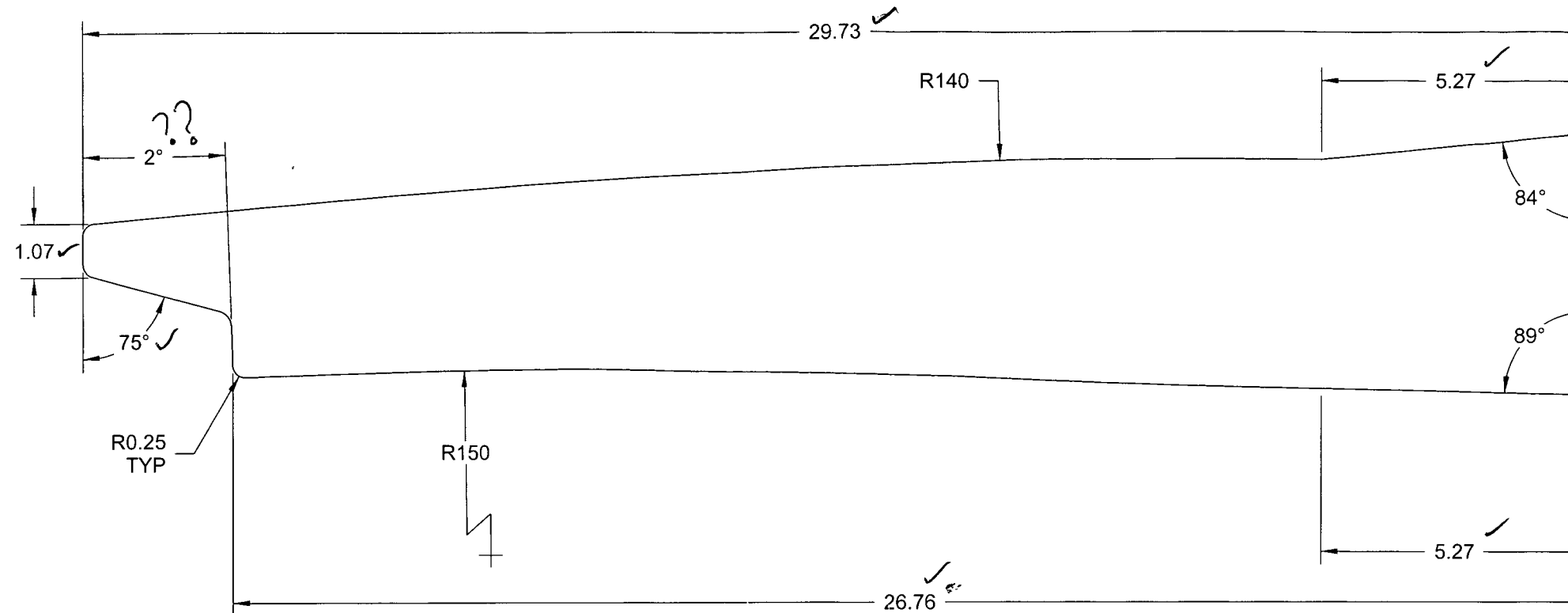
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs
- 8) MANUFACTURE PART FROM "D3701-1F.DXF" FILE

**PRELIMINARY  
ISSUE**

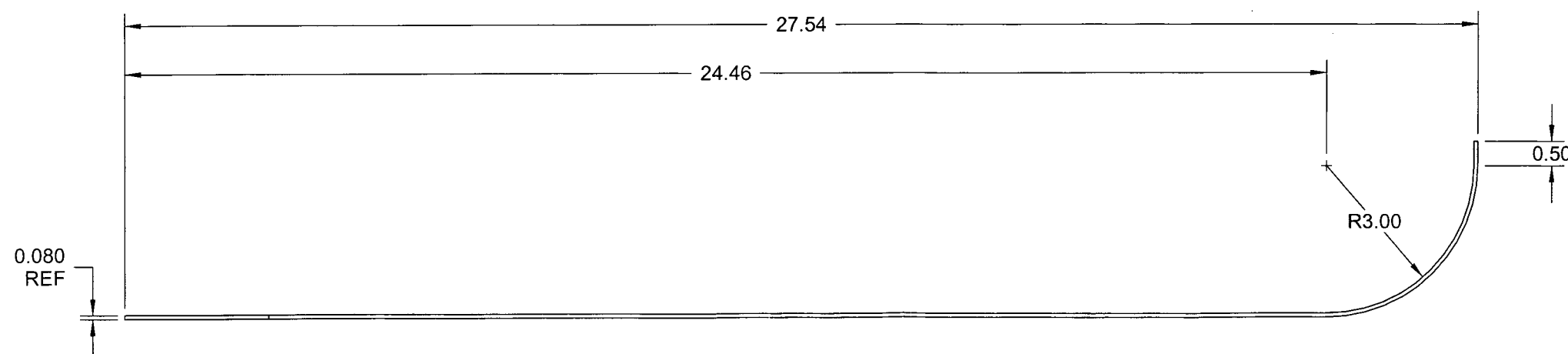
*08/04/30 MP*

**PROTOTYPE**

A	NEW ISSUE		MB	08.04.30
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.		REV. A
MFG. APPR.		D3701		SHEET 1 OF 2
APPROVED		TITLE		SCALE
DE APPR.		FLOOR DOUBLER		NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



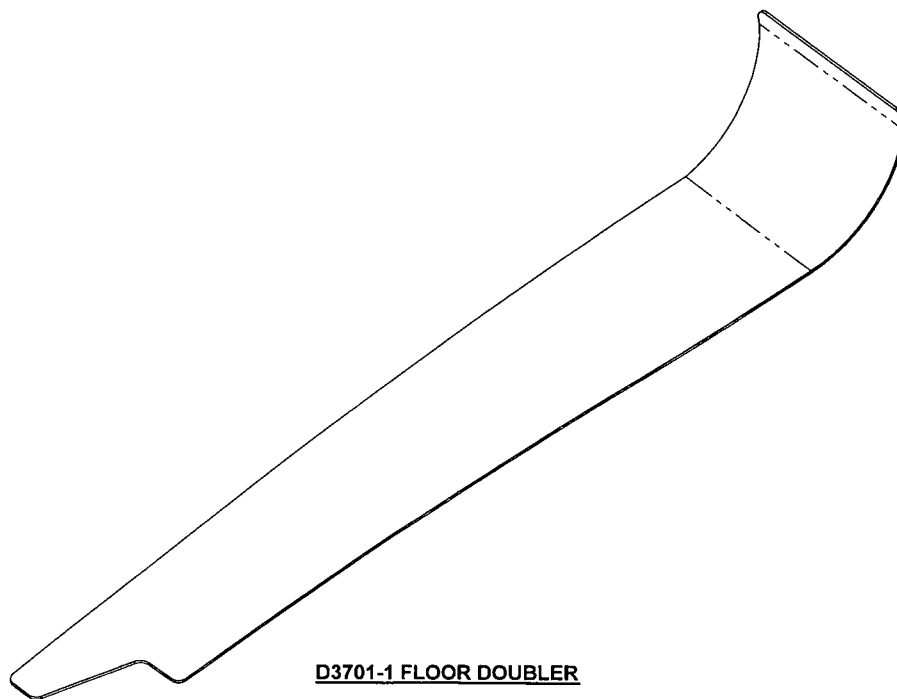
**D3701-1F FLAT PATTERN**



**D3701-1 FLOOR DOUBLER**  
(MAKE FROM D3701-1F)

**PROTOTYPE**  
**PRELIMINARY ISSUE**  
08.04.16  
for ECN#09-502P.

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. <b>D3701</b>	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>FLOOR DOUBLER</b>	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3701-1 FLOOR DOUBLER**

440 05061

**NOTES:**

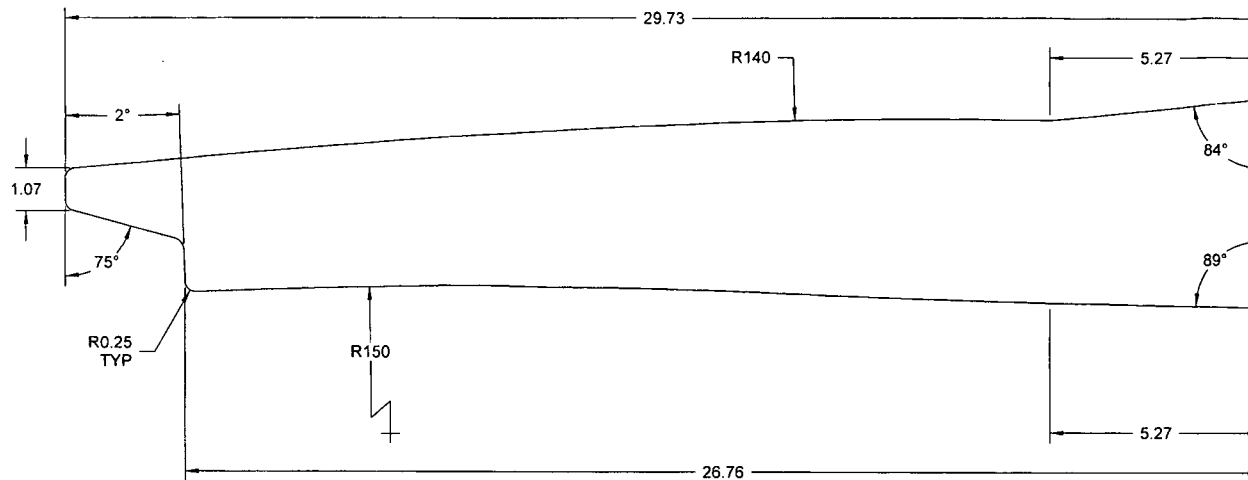
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs
- 8) MANUFACTURE PART FROM "D3701-1F.DXF" FILE

**RELEASED**  
9/16/18

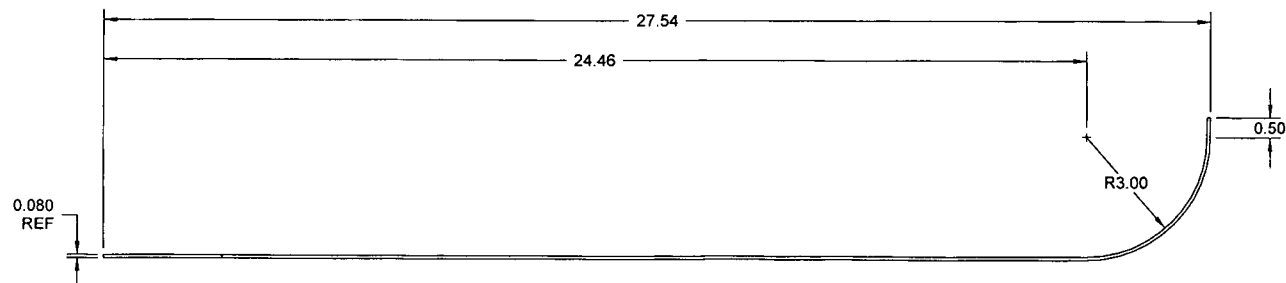
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.30		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3701</b>	REV. A
TITLE <b>FLOOR DOUBLER</b>	SHEET 1 OF 2
SCALE NTS	
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





**D3701-1F FLAT PATTERN**



**D3701-1 FLOOR DOUBLER**  
(MAKE FROM D3701-1F)

**RELEASED**  
09/04/08

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3701	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR DOUBLER	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

4605061